

Work Order ID 83846

83846

Page 1

Thursday, April 26, 2012 1:28:19 PM

Item ID: D4155-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 4/26/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	---------------

Draw Nbr

Revision Nbr

D4155

C

0.00

0.00

0.00

0.00

100

Cold Saw

Hyd Mech

Memo

Cut blanks at 91.59"

110

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Mill as per folio FB048 & dwg D4155

FOLIO REV: FA

DWG REV: CA

2-Debur as required

only 12/05/17

B.A 12/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4155-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 4/26/2012 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 5/4/2012 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120			B.n	12/05/24		6	φ		
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130			ork	12/05/26		6	φ		
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									

(X6)

ML 12-06-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Thursday, April 26, 2012 1:28:19 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/26/2012 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 5/4/2012 **Req'd Qty:** 16.00

16

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

11206-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, April 26, 2012 1:28:23 PM

Page 1

Work Order ID: 83846

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Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 4/26/2012

Required Date: 5/4/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	142.0800	7.6333	128.5608			

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT050

142.08

121216

142.08

M120696 X 7.6333

M121547 X 38.166

45.7998

OK 12/05/17

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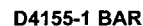
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NO. 83846

10/2-04-26



2) FINISH : NONE
3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS : INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
6) IDENTIFICATION : NONE
7) WEIGHT : 2.69 lbs

DEL 2012-04-11

C	REMOVED TOOLING HOLE. ADD CUT OUT PROFILE (ZN C6-1 & C7-1); 2 DEC TOLERANCE (D1-1, D2-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS. MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4155	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BAR	NT
DATE	12.02.21	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN APPROVAL OF DART AEROSPACE USA, INC.	

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